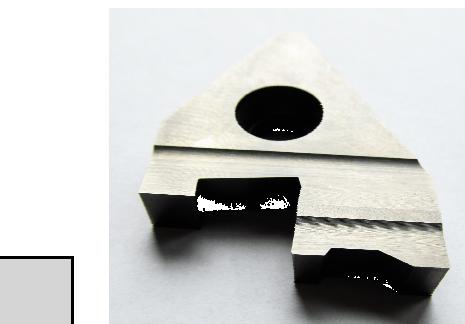
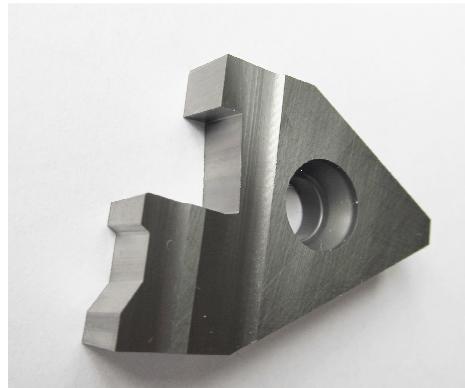


Turning Insert width 36mm

A08-010

The rakeform of the double chipbreaker is interpolated while oscillating along the length of blank to achieve a straight bottom line. 2 pregrinding passes are roughing the profile with passes of 2 mm. The 3 pregrind process prepares the profile for the final finishing pass with overmeasure of 0.06 mm. The Insert is clamped in an adapted cartridge corresponding to the V-reference faces of the blank. If the references are not ground, a TTC clamping can be recommended allowing to grind around the insert: profile, chipbreaker as well as reference faces.



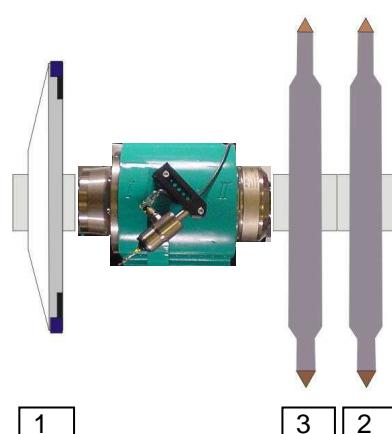
1. Cycletime for Production

Workpiece: B 36 mm, T 6 mm Material CARBIDE						
Operations	Chipbreaker	Chipbreaker 2	Pregrind 1	Pregrind 2	Pergrind 3	Finishing
Feed [mm/Min]	500	500	25	25	40	60
Power [kW]	1	1	4	3	2	2
Cutting speed [m/s]	22	22	22	22	22	22
Used wheels	1	1	2	2	2	3
Grinding time [s]	47	47	285	318	125	120
Total cycle time	15 Min 43					

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	12C9 Ø250 D64
2	14V1 Ø300 D64V40°
3	14V1 Ø300 D46V40°



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 31iA5

Software: Quinto 5

Accessories:

Responsible engineer: OP. 3.7.12

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